

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014885**Date Inspected:** 10-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng Wei, Zhu Zhong Hai.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 12AW, Corner Assembly, Edge Panel to Side Panel.

FCAW Repair welding of weld joint CA3007-003 (WRR # Temporary); located at assembly, Bay 14, 12AW. Welder is identified as 047866; ZPMC Quality Control Inspector (QC) is identified as Zhu Zhong Hai. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-REPAIR.

Assembly, Bay 14, 12BW, Corner Assembly, Edge Panel to Side Panel.

FCAW Repair welding of weld joint CA3008-003 (WRR # Temporary); located at assembly, Bay 14, 12BW. Welder is identified as 201215; ZPMC Quality Control Inspector (QC) is identified as Zhu Zhong Hai. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-REPAIR.

Assembly, Bay 14, 12CE, Corner Assembly.

During Random Visual in process Inspection, this QA inspector observed fit-up of Corner Assembly CA3004 to Segment 12CE. The attached photographs provide additional detail.

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Assembly, Bay 14, 12AE.

During Random Visual in process Inspection, this QA inspector observed fit-up of Corner Assembly CA3001A (X3039A) to Floor Beam FB3037A (X3006A). The attached photographs provide additional detail.

Assembly, Bay 14, 12CE, Stiffener to Longitudinal Diaphragm.

FCAW welding of weld joint SEG3003B-145, 146; located on assembly, Bay 14, 12CE. Welder is identified as 048038; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4C-F.

This QA Inspector carried out NDE on following

Blast shop 01, 9DW.

This QA inspector performs Random Visual Testing (VT) after blast; of area previously tested and accepted by ZPMC Quality Control personnel of Segment 9DW (interior). Indications found were documented & marked for further processing.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By: Juvekar,Amit

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer
